

Work Order ID 66079

Page 1

Thursday, February 03, 2011 3:10:11 PM

Item ID: D3254-2

Accept



Setup Start



Revision ID:

Item Name: Side (RH)

Stop



Start Date: 2/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *MW*

Date: 11-02-03 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3254	Rev A

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

D3254 .063

Memo

1-Cut as per Dwg D3254 Dwg Rev: *A* Prog Rev: *A* 2-
Deburr if necessary*B11-3-10**(4)*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

*B11-3-10**(4)*

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

M *11* *03* *10* *(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M 112588.

0.00

H BK 11-3-15.

Powder Coating

Memo

0.00

170

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

4 9 H 110315

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: 414

0.00

4/3/15 SP CWD

Memo

0.00

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Revision ID:

Item Name: Side (RH)

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Start Date: 2/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC21- Final Inspection - Work Order Release

0.00

11/3/16 AF

QC

Quality Control

Memo

0.00

MP
11-03-15

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Picklist Print

Page 1

Thursday, February 03, 2011 3:10:03 PM

Work Order ID: 66079



Parent Item: D3254-2



Parent Item Name: Side (RH)

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3254-2 no longer made in-house
IPP c 08.11.13 in-house EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			100	sf	55.9270	3.37	14.18947	16.		 B311-3-10

2024-T3 .063 sheet

Location	Loc Qty	Loc Code
MAT22	55.927	
114351	55.927	
117018		117018

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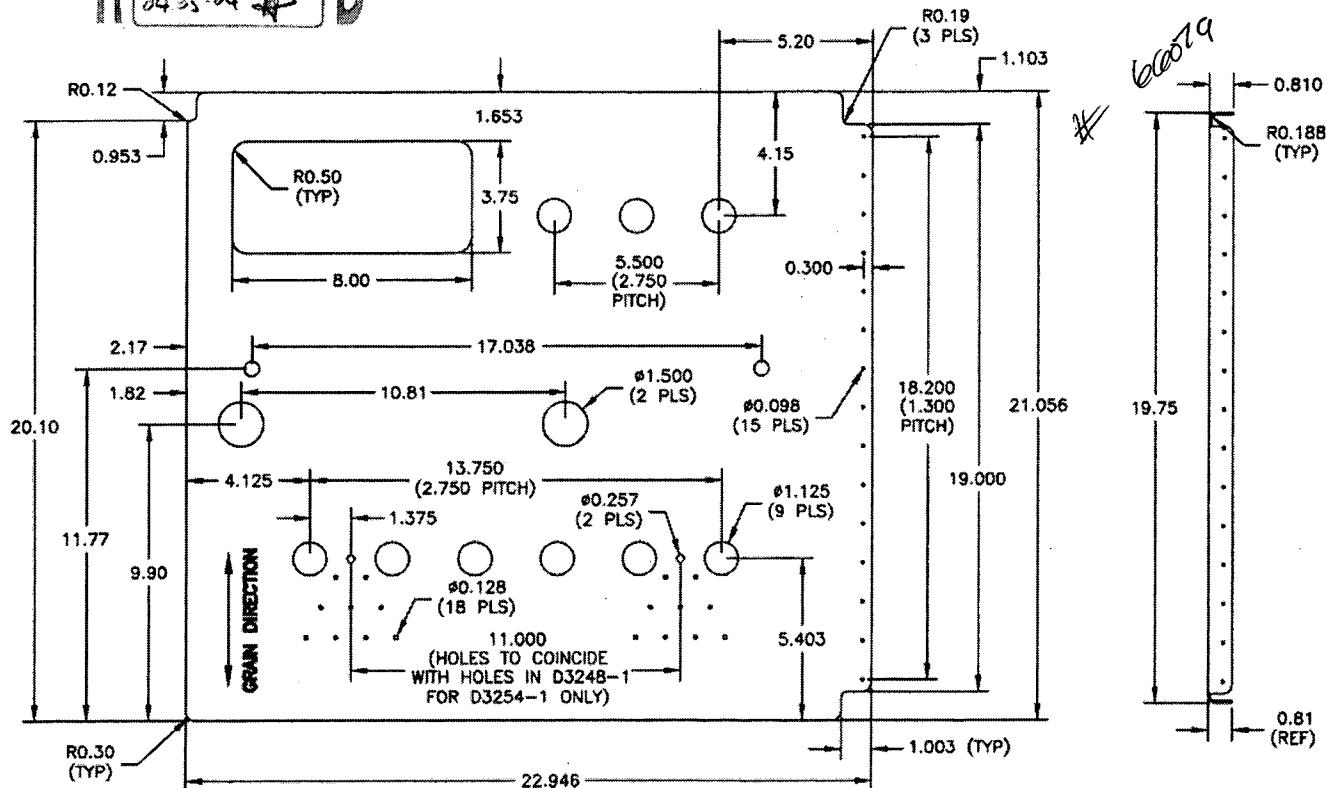
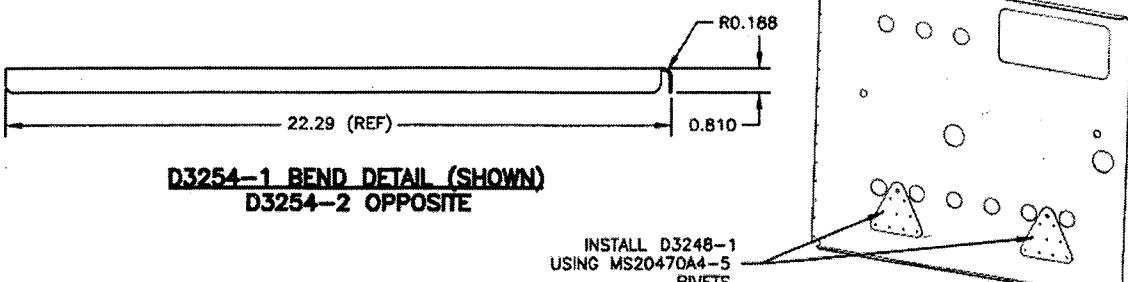
NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>OP</i>	APPROVED <i>RF</i>	DRAWING NO. D3254	REV. A
DATE 04.04.06	TITLE SIDE (DUAL BATTERY RACK)	SCALE 1:6	SHEET 1 OF 1
A	04.04.06	NEW ISSUE	

RELEASED

04.05.04

**D3254-1/-2 FLAT PATTERN****D3254-041****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	06079
Description: Side (Dual Battery Rack)	Part Number:	D3254-2
Inspection Dwg: D3254 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>ML</u>	Prototype Approval:	N/A
Date:	11-3-10	Date:	11-03-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	P/O D205-579-015	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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				<i>No OKs</i>				

NOTE: Date & initial all entries